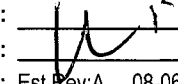
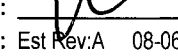


Date: Tuesday, 08/07/2008 1:46:50 PM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	FORWARD GUIDE PLATE
Job Number :	40371		
Estimate Number :	13366		
P.O. Number :		Part Number :	D358911
This Issue :	08/07/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3589 REV B PRELIM 08.07.14
First Issue :	//	Project Number :	N/A
Previous Run :	05029	Drawing Revision :	B PRELIM
Written By :		Material :	
Checked & Approved By :		Due Date :	15/07/2008
Comment :	Est Rev:A 08-06-05 new issue DD verified by:ec		

Qty: 1 Um: Each

Additional Product

PRELIMINARY ISSUE

POSITIVE
RECALL

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304S16GA	304/316 .063 Sheet
-----	-----------	--------------------



Comment: Qty.: 0.0483 sf(s)/Unit Total : 0.0483 sf(s)
 304/316 .063 Sheet
 batch: ~~108156~~ 108156 HB 8-7-15
 ml 08 07 09

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3589
 Dwg Rev: B *prelim*
 Prog Rev: B *prelim* } ml HB 8-7-15
 08 07 09
 2-Debur if necessary

(1)

(1)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

(1)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

508/07/15 **ENGINEERING APPROVAL**
 508/07/09 (1)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: Form as per dwg D3589 using DT9021






HB 08.07.15

HB 08/07/16 (1)

HB 08 07 09 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3589-11 PAR #: N/A Fault Category: Eng / Dwg. NCR: Yes ☐ No ☒ DQA: D Date: 09/02/15
 QA: N/C Closed: Date:

NCR: <u>40371</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.08.06	5.0	PART WAS NOT AUGMENTED CORRECTLY UPON WELDING	 08.08.06	SCRAP & MAKE NEW PART PER NEW DWG	 08.08.06	 8/8/06	 08.08.06	 8/8/06

NOTE: Date & initial all entries

Date: Tuesday, 08/07/2008 1:46:50 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FORWARD GUIDE PLATE

Job Number: 40371

Part Number: D358911

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



ENGINEERING
APPROVAL

Comment: INSPECT WORK TO CURRENT STEP

Soot 07/16/08

08/07/10

7.0

PACKAGING 1

PACKAGING RESOURCE #1



USED w/
D3589-041

Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: _____

08.08.00
capacities

08.07.16

PD 08-07-14

P/N: B40366

08.07.21

8.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/17

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 08.07.21

POSITIVE RECALL

EFFECTIVE

AUTH

RELEASED

DATE

POSITIVE RECALL

EFFECTIVE

AUTH

RELEASED

DATE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	240371
Description: Forward Guide Plate	Part Number:	D3589-11
Inspection Dwg: D3589 Rev: B prelim		Page 1 of 1

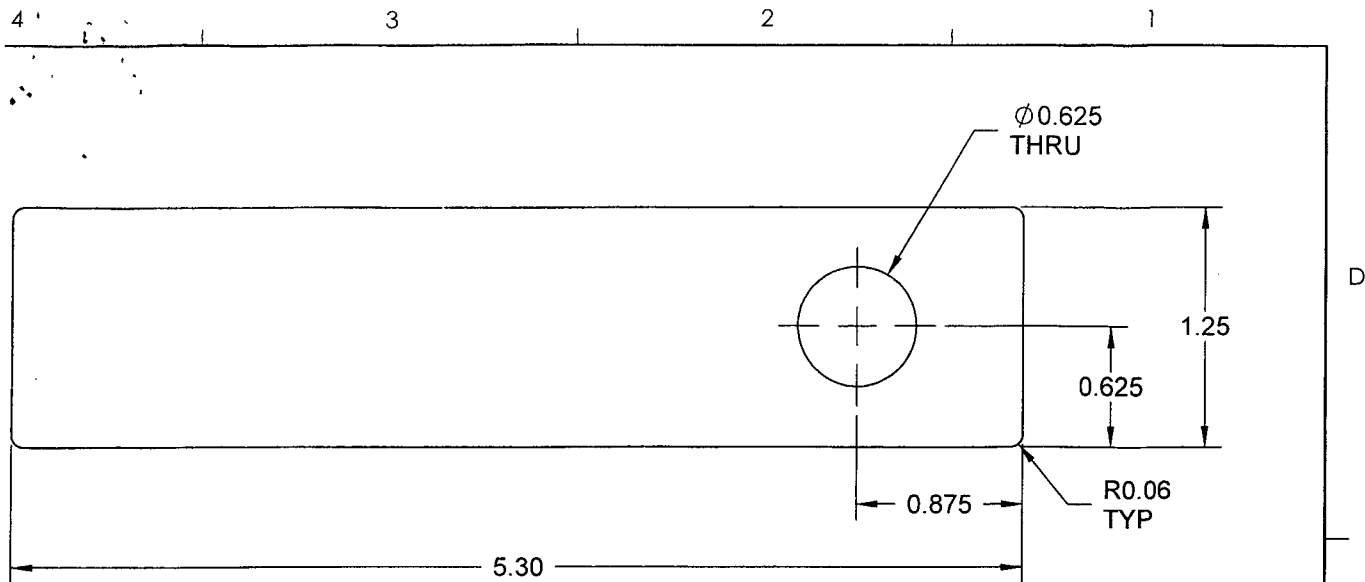
FIRST ARTICLE INSPECTION CHECKLIST

<input checked="" type="checkbox"/> First Article	<input type="checkbox"/> Prototype
<p>1. Introduction</p> <p>2. Materials and Methods</p> <p>3. Results</p> <p>4. Discussion</p> <p>5. Conclusion</p>	<p>1. Introduction</p> <p>2. Materials and Methods</p> <p>3. Results</p> <p>4. Discussion</p> <p>5. Conclusion</p>

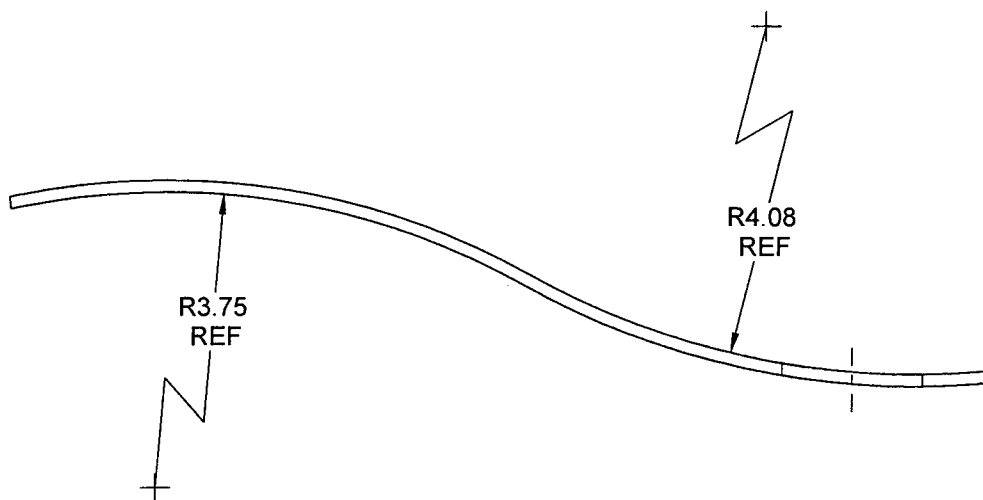
[illegible]

Measured by:	<i>M. M.</i>	Audited by:	<i>S.</i>	Prototype Approval:	<i>n/</i>
Date:	<i>08.07.09</i>	Date:	<i>08/07/09</i>	Date:	<i>4</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D3589-11F FORWARD GUIDE PLATE
FLAT PATTERN



8 D3589-11 FORWARD GUIDE PLATE
(MAKE FROM D3589-11F)

40371

PRELIMINARY ISSUE
08.06.26

STAINLESS STEEL SHEET,
3 OR AMS 5524,
9 (ANNEALED) 2B FINISH
0.063 THICK),
SPEC M304S16GA)

T QSI 018 UNLESS

OTHERWISE NOTED
0.005 TO 0.010 MAX

T9021 TEMPLATE

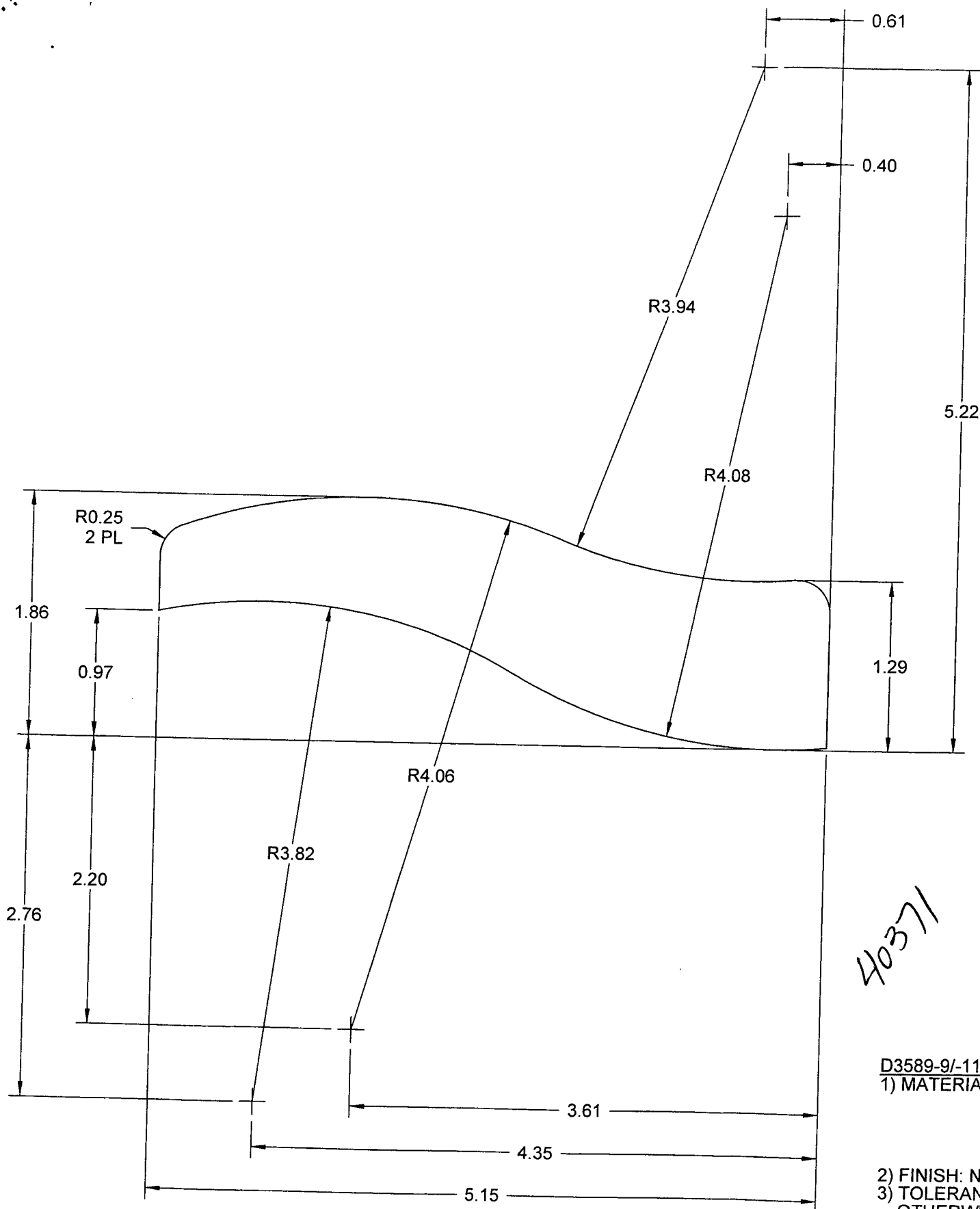
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO. D3589	REV. B
MFG. APPR.			SHEET 6 OF 8
APPROVED		TITLE FORWARD GUIDE PLATE	SCALE
DE APPR.			NTS
DATE	08.06.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8

7

6

5

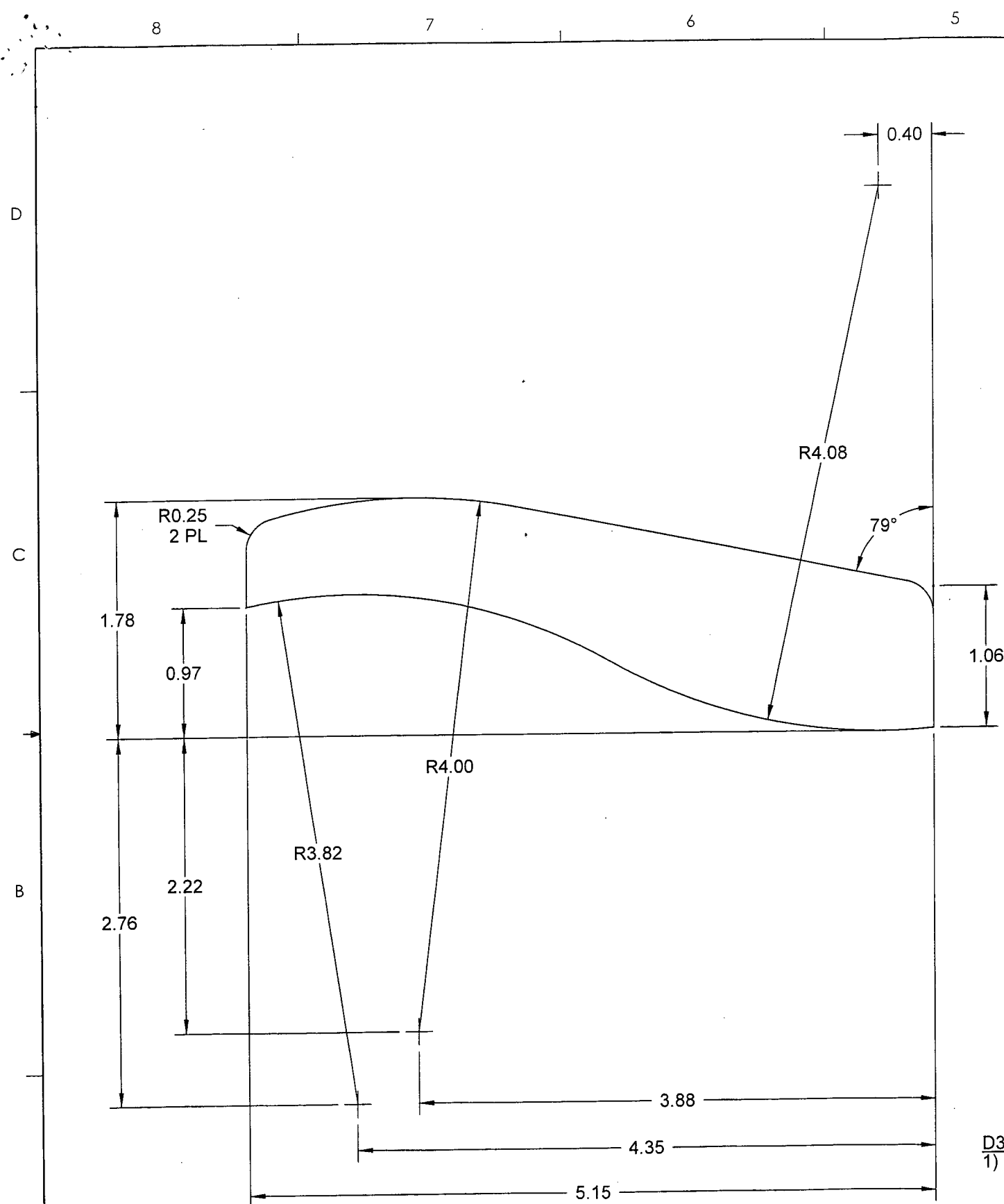


D3589-9 FORWARD GUIDE PLATE

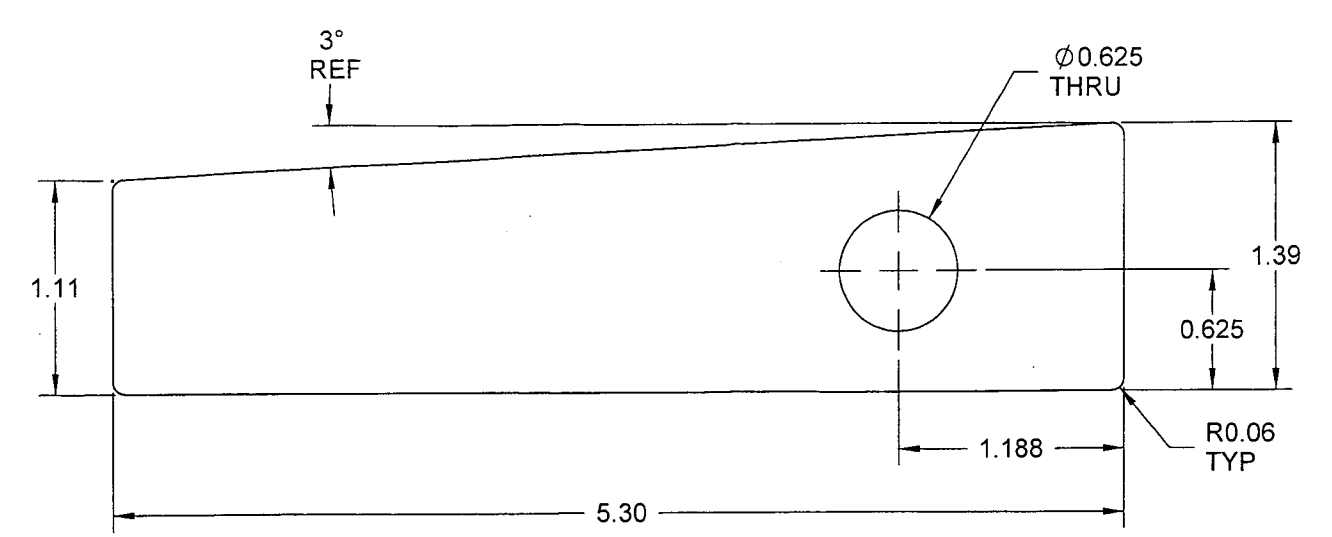
D3589-9/-11/-11F NOTI

1) MATERIAL: AISI 304
PER AM
OR MIL-
16 GAUC
(REF. D/

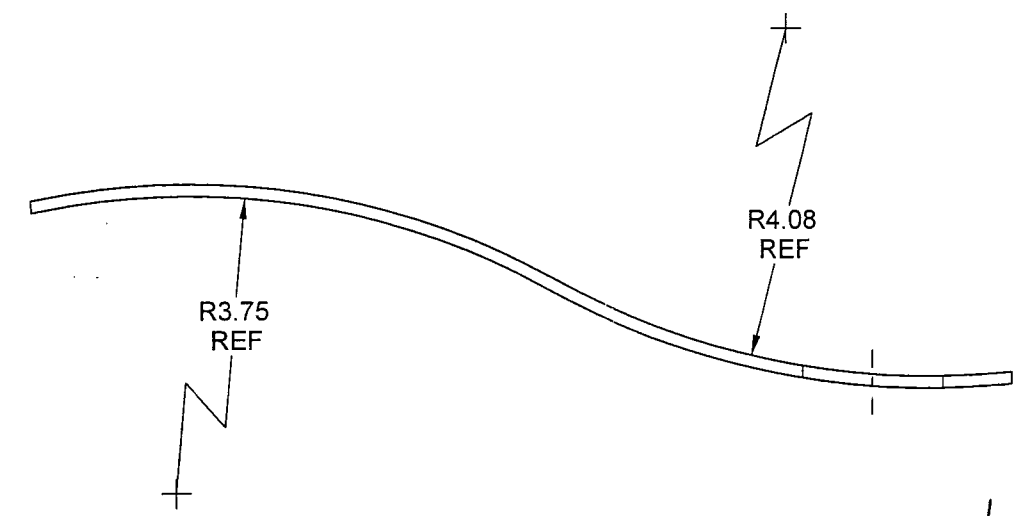
2) FINISH: NONE
3) TOLERANCES: PER
OTHERWISE NOTED
4) UNITS: INCHES UNL
5) BREAK SHARP EDG
6) IDENTIFICATION: N/
7) WEIGHT: 0.10 lbs E/
8) CONTROL SHAPE PI



D3589-9 FORWARD GUIDE PLATE



**D3589-11F FORWARD GUIDE PLATE
FLAT PATTERN**



**D3589-11 FORWARD GUIDE PLATE
(MAKE FROM D3589-11F)**

- D3589-9/-11/-11F NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH 16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.09 lbs EACH
 - 8) CONTROL SHAPE PER DT9021 TEMPLATE

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3589	REV. B
MFG. APPR.			SHEET 6 OF 8
APPROVED		TITLE FORWARD GUIDE PLATE	SCALE NTS
DE APPR.		COPYRIGHT © 2008 BY DART AEROSPACE LTD	
DATE	08.06.25	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

PRELIMINARY ISSUE

2008.07.14

2008.02.14

Date: Tuesday, 08/07/2008 1:46:50 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FORWARD GUIDE PLATE
 Job Number : 40371
 Estimate Number : 13366
 P.O. Number :
 This Issue : 08/07/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D358911
 First Issue : / / Type : SMALL /MED FAB Drawing Number : D3589 REV B PRELIM
 Previous Run : 05029 Project Number : N/A
 Material :
 Due Date : 15/07/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A 08-06-05 new issue DD verified by:ec

Additional Product

PRELIMINARY ISSUE



Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S16GA 304/316 .063 Sheet



Comment: Qty.: 0.0483 sf(s)/Unit Total : 0.0483 sf(s)
 304/316 .063 Sheet
 batch: ~~108153~~ 108156 ml 08 07 09

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3589

Dwg Rev: B Prelim

Prog Rev: B Prelim

2-Deburr if necessary

ml 08 07 09

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

508/07/15 ENGINEERING APPROVAL

508/07/08

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: Form as per dwg D3589 using DT9021

ml 08 07 09

508 07/07/06

508 07/07/09

Dart Aerospace Ltd

Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613) 632-3336
Fax: (613) 632-4443

Receiving Slip

Date May 29, 2008	Page 1
Receipt Number RCP00008000	

Purchase From:

Magna Stainless
525 avenue Meloche
Dorval, QC H9P 2W2
Canada

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Description	Contact	Vendor Number	PO Number
			VC-MAG002	PO00006445

Vendor Item Number	Item Number	Description	Qty. Received	UOM	Unit Cost	Extended Cost	Arrival Date
	M304R1250	Inventory	25.3333	f	13.166666	333.56	May 29, 2008
		NOTE: AISI 303 NOT ACCEPTABLE MATERIAL : AISI 304/316 SS ROUND BAR B/N108156					
	M304S11GA	304/316 .125 Sheet	32.0000	sf	13.375000	428.00	May 29, 2008
		ANNEALED 2B FINISH MATERIAL: AISI 304/316 SS SHEET B/N108156					
	M304S16GA	304/316 .063 Sheet	160.0000	sf	6.718750	1,075.00	May 29, 2008
		MATERIAL: AS ABOVE B/N108156					
	M304S18GA	304/316 .050 Sheet	96.0000	sf	5.312500	510.00	May 29, 2008
		MATERIAL: AS ABOVE B/N108156					
	M304S20GA	304/316 .040 Sheet	160.0000	sf	4.062500	650.00	May 29, 2008
		MATERIAL: AS ABOVE B/N108156					

Comments:

CF 944



AK Steel Corporation
Metallurgical Test Report
Rockport Works
Rockport, IN 47635

Page 1

Load No. 8869723

SRN No. 8869723

CUSTOMER

SHIP TO

MILL ORDER NO. 278523-0105
PROCESSOR ORDER NO. 1265
BUYERS ORDER NO. 1265

PART NO.
304-2B 16X48

ENGLISH UNITS - PRODUCT:- METRIC UNITS
.0595 NOM 48.0000 X COIL

COIL ID	PIECE	HEAT	PARENT COIL ID	NET WEIGHT	OUTSIDE PROCESSOR ID
987300-14ABB	1	7380069	0987300-14A	13,060 LBS. 5,924 KG.	464969605
TOTAL COILS	TOTAL PIECES			TOTAL NET WEIGHT	
1	1			13,060 LBS. 5,924 KG.	

L-Ladle Analysis of Heat

P-Product Analysis of Parent Coil

CHEMICAL ANALYSIS

ID	C	MN	P	S	SI	CR	NI	MO	N	CU						
L 7380069	.051	1.338	.026	.0013	.490	18.18	8.20	.28	.0310	.31						

REMARKS: NO INTENTIONAL ADDITIONS OF MERCURY OR MERCURY COMPOUNDS WERE
MADE OR USED THROUGHOUT THE PROCESSING AND TESTING OF THIS MATERIAL
MATERIAL FREE OF RADIOACTIVE ISOTOPES
ROHS COMPLIANT
MELTED AND MANUFACTURED IN THE USA

PRODUCT DESCRIPTION

CR SHT TYPE 304 STAINLESS #2B FINISH SLIT EDGE TEST REPORTS * GULF & NORTHERN TRADING CORP. - CR REV.2 WITH AK STEEL TECHNICAL
EXCEPTIONS DATED 04/26/07 AND ACCEPTED BY THE CUSTOMER ON 05/04/07 * ASTM A 240 -07 (UNS S30400). * ASTM A 480 -06 EX PARA 25.1
.1.3 COIL WILL BE TAGGED ON OUTSIDE ONLY * ASME SA-240 SECTION II PART A (2004 ED, 2005 ADDENDA) * ASME SA-480 SECTION II PART A
(2004 ED, 2005 ADDENDA) * ASTM A 666 -03 EX 7.1 TEST SPECIMENS WILL BE SELECTED IN THE TRANSVERSE TEST DIRECTION IN ALL CASES *
AMS 5513 H * ASTM A 262 -02AE2 PRACTICE E

PARENT COIL ID	POS (FT)	DIR (L, T, D)	COND	% ELONG	TENSILE STRENGTH (KSI)	Y.S. 2% OFFSET (KSI)	ROCKWELL HARDNESS Tail	ROCKWELL HARDNESS Front			
0987300-14A	T	T	A.S.T.M	60.7	95.5	41.6	B 83	B 86			

*** CONTINUED ON NEXT PAGE ***

3/004 Fax Server

AK Steel RightFax

Date: -Wednesday, 06/08/2008 3:18:43 PM

User: Julie Lecocq

JOB HISTORY : DETAIL

Job Number	: 40371	Customer	: Dart Helicopters Services
Estimate Number	: 13366	DWG Name	: FORWARD GUIDE PLATE
Purchase Order #	:	Part Number	: D358911
Complete Date	: 21/07/2008 1:32:13	DWG Number	: D3589 REV B PRELIM
Rev.	: B PRELIM		

DUE DATE	ORDERED	DELIVERED
15/07/2008	1	1

1.0 M304S16GA-304/316 Sheet .063	INVENTORY ITEM
---	-----------------------

DATE	EMPLOYEE	TYPE	Qty	COST	
15/07/2008	BLEC01: Bleck, Henry	M304S16GA	0.060	\$0.43	Lot # 108156 Qty. 0
Subtotal:	QTD:	0 CTD:	0	\$0.43	

2.0 WATER JET	Internal Operation
----------------------	---------------------------

DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach.Cost
09/07/2008	MURD02: Murdoch, Matthew	Run	1.000	0.23	\$3.72	0.24	9.43
15/07/2008	BLEC01: Bleck, Henry	Run	1.000	0.00	\$0.00	0.00	0.00
Subtotal:	QTD:	2 CTD:	0	0.23	\$13.15		

5.0 SMALL FAB 1	Internal Operation
------------------------	---------------------------

DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach.Cost
09/07/2008	BOUC01: Boucher, Sylvie	Run	0.000	1.05	\$17.69	1.05	42.99
09/07/2008	BOUC01: Boucher, Sylvie	Run	0.000	0.75	\$12.64	0.75	30.71
16/07/2008	BOUC01: Boucher, Sylvie	Run	1.000	0.62	\$10.45	0.62	25.39
Subtotal:	QTD:	1 CTD:	0	2.42	\$139.87		

Total:		TIME	COST
	Machine Time:	2.66	\$108.52
	Labor:	2.65	\$44.50
	Sub-contract (external Op.):		\$0.00
	INVENTORY ITEM:		\$0.43
	SUB-COMPONENT (SUB-JOB):		\$0.00
			\$153.45

COST PER UNIT:	\$153.45
-----------------------	----------

Fax Server

AK Steel RightFax



AK Steel Corporation
Metallurgical Test Report
Rockport Works
Rockport, IN 47635

Page: 2

Load No. 8869723
SRN No. 8869723

C U S T O M E R		S H I P T O		MILL ORDER NO.	PROCESSOR ORDER NO.	BUYERS ORDER NO.
				278523-0105	1265	1265
				PART NO.		
				304-2B 16X48		
				ENGLISH UNITS	-PRODUCT:-	METRIC UNITS
				.0595 NOM	48.0000 X COIL	

PARENT COIL ID	POS (F/T)	DIR (L, T, D)	COND	ASTM A 262 PRACTICE E	BEND 180 IT						
0987300-14A	T		A.S.T.M	PASS	PASS						

THE CHEMICAL ANALYSIS AND PHYSICAL OR MECHANICAL TESTS REPORTED ABOVE ARE CORRECT
AS CONTAINED IN THE RECORDS OF THE CORPORATION.

ALL TESTING IS DONE IN ACCORDANCE WITH A.S.T.M STANDARDS UNLESS OTHERWISE NOTED

AK Steel Corporation

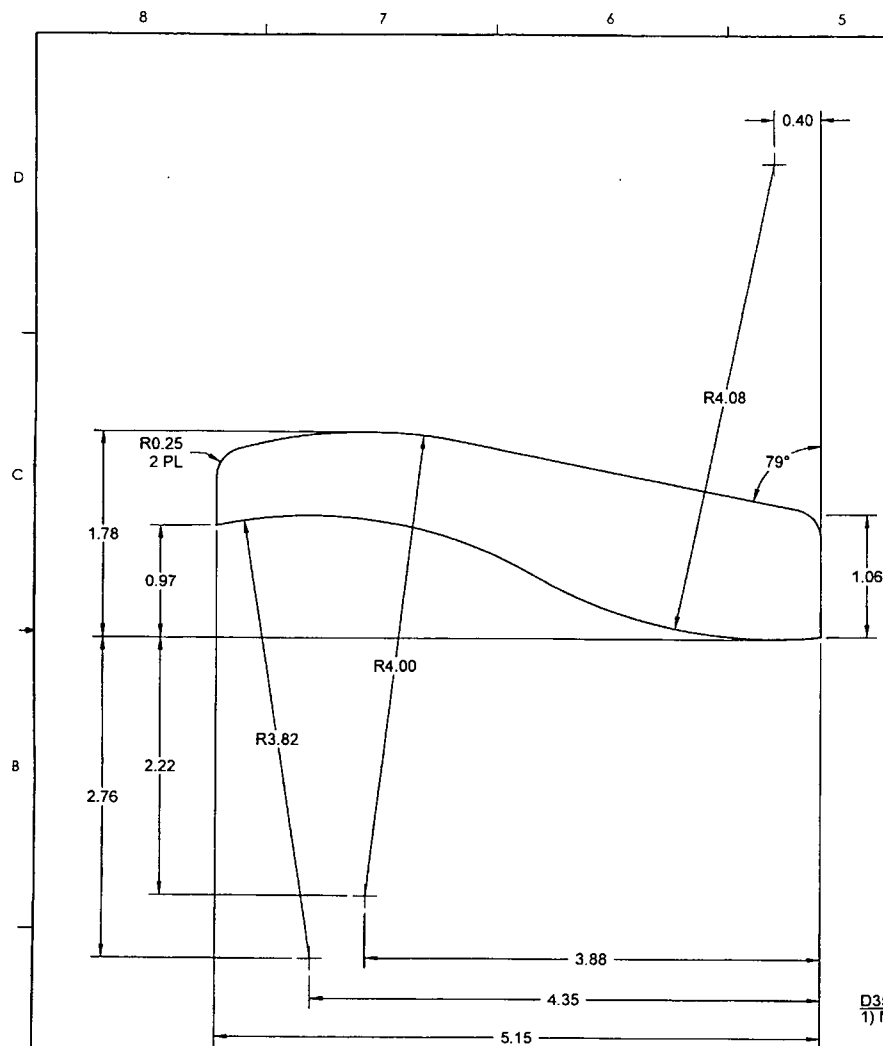
MSWQC#0049 5/95

"THIS CERTIFIED TEST REPORT HAS BEEN DELIVERED TO A CONSIGNEE OF MATERIAL PURCHASED FROM AK
Steel Corporation. TO AVOID THE POSSIBILITY OF ITS MISUSE ON DELIVERY OF THE REPORT TO A
THIRD PARTY IT MUST BE RE-CERTIFIED BY AND UNDER THE NAME OF SUCH CONSIGNEE"

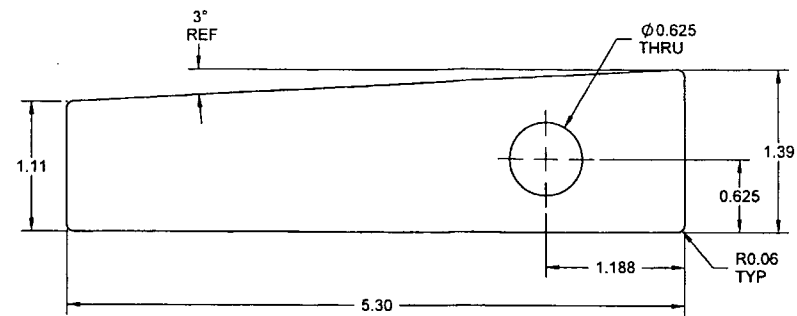
SIGNED

QUALITY MANAGER

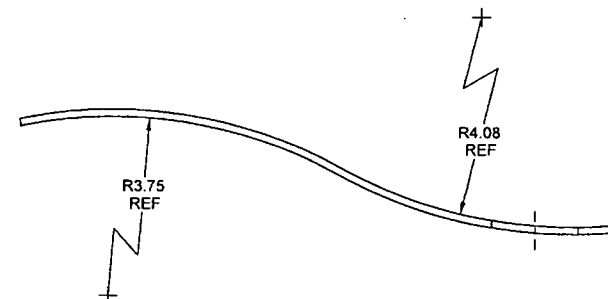
DATE 03/26/2003 TIME 08:02 AM



D3589-9 FORWARD GUIDE PLATE









D3589-11F FORWARD GUIDE PLATE
FLAT PATTERN



D3589-11 FORWARD GUIDE PLATE
(MAKE FROM D3589-11F)

D3589-9/-11/-11F NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH 16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.09 lbs EACH
- 8) CONTROL SHAPE PER DT9021 TEMPLATE

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3589	SHEET 6 OF 8
APPROVED		TITLE	SCALE
DE APPR.		FORWARD GUIDE PLATE	NTS
DATE	08.06.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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RELEASED
9/2/07

40371